

Work Order ID 58592

Wednesday, May 12, 2010 8:44:37 AM



Page 1

Item ID: D4016-5

Accept



Setup

Start



Revision ID:

Item Name: Hinge Half, Light Lid

Stop



Start Date: 5/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-5-12 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D4016	A								
-------	---	--	--	--	--	--	--	--	--

100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00	<i>10-5-12</i>	<i>10/05/14</i>	<i>6</i>	<i>0</i>			

Jeaspa Bandsaw	CUT BLANK as per folio								
----------------	------------------------	--	--	--	--	--	--	--	--

110		0.00							
HAAS 1	Memo	0.00	<i>10-5-12</i>	<i>10/05/15</i>					

HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA874 AND DWG FOLIO REV: <u>AA</u> DWG REV: <u>A</u>								
------------------------------	---	--	--	--	--	--	--	--	--

DEBURR

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58592

Wednesday, May 12, 2010 8:44:37 AM



Page 2

Item ID: D4016-5

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Light Lid

Start Date: 5/12/2010 Start Qty: 6.00



Stop



Required Date: 5/14/2010 Req'd Qty: 6.00



Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

88 10/05/15

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

10/05/16

6

160



Packaging

Packaging

Identify as per dwg & Stock Location: basket

0.00

Memo

0.00

⑥ 10.05.13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58592

Wednesday, May 12, 2010 8:44:37 AM



Page 3

Item ID: D4016-5

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Light Lid

Start Date: 5/12/2010 Start Qty: 6.00



Stop



Required Date: 5/14/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

10/05/18 AJ

010-5-15
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 12, 2010 8:44:36 AM

Page 1

Work Order ID: 58592



Parent Item: D4016-5



Parent Item Name: Hinge Half, Light Lid

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD
as per dwg REV.A DD 10.02.22 verified by:EC

IPP Rev:B

Start Date: 5/12/2010

Start Qty: 6.00

Required Date: 5/14/2010

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B0.750X00.75 0		Purchased	No			100	f	14.0831	0.09			

6061-T6 Bar .750 x .750



Location	Loc Qty	Loc Code
MAT02	14.0831	
108877	1.62	
→112567	12.4631	

5685 on 2/10/08 by

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

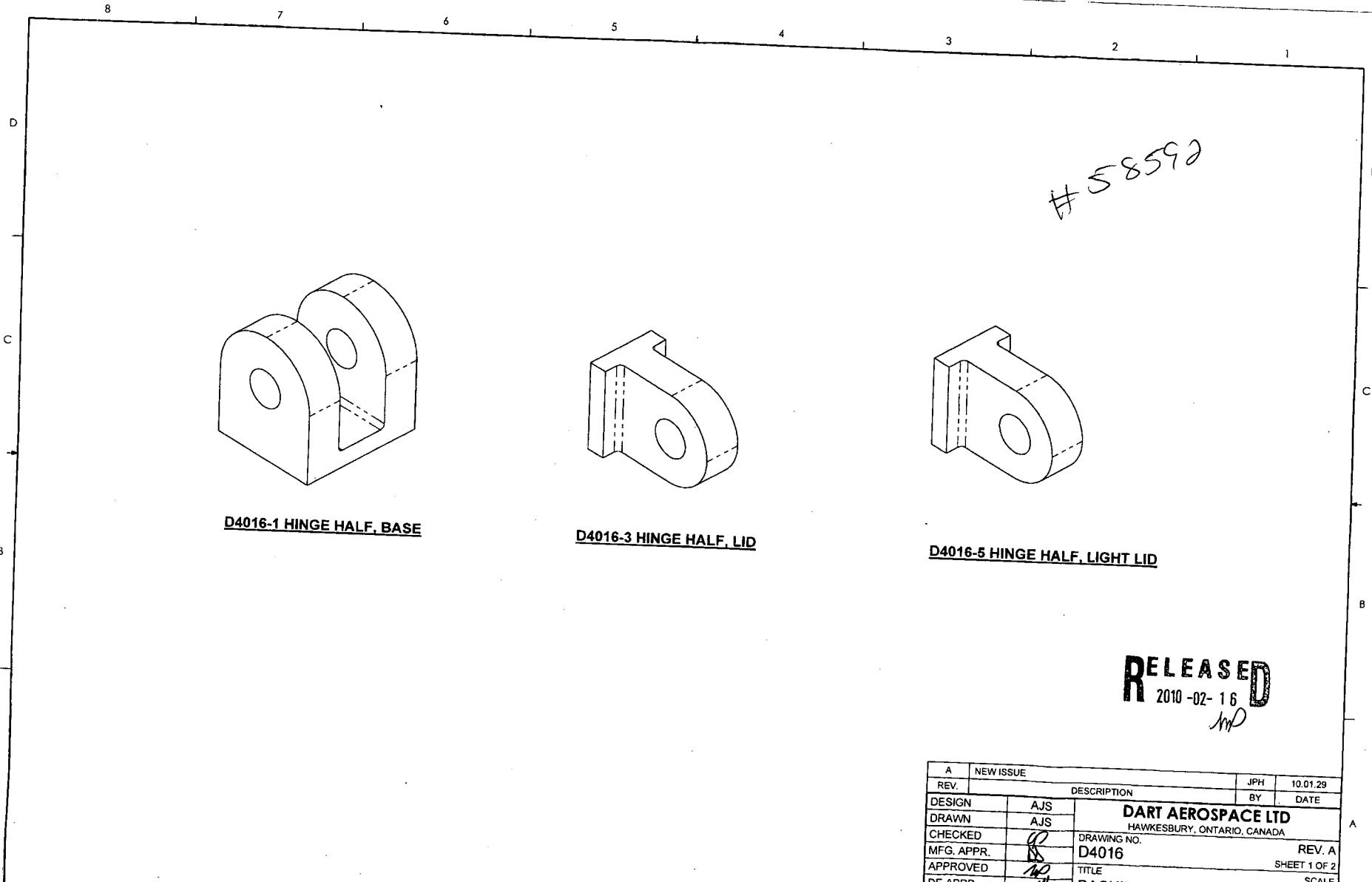
DART AEROSPACE LTD	Work Order:	58592
Description:	Part Number:	D401b-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SP</u>	Audited by: <u>SL</u>	Prototype Approval: N/A
Date: <u>10/05/14</u>	Date: <u>10/05/16</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



RELEASED
2010-02-16
MP

A	NEW ISSUE	JPB	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DD	DRAWING NO.	
MFG. APPR.	AA	D4016	REV. A
APPROVED	AA	TITLE	SHEET 1 OF 2
DE APPR.	AA	BASKET HINGE	SCALE
DATE	10.01.29	NTS	

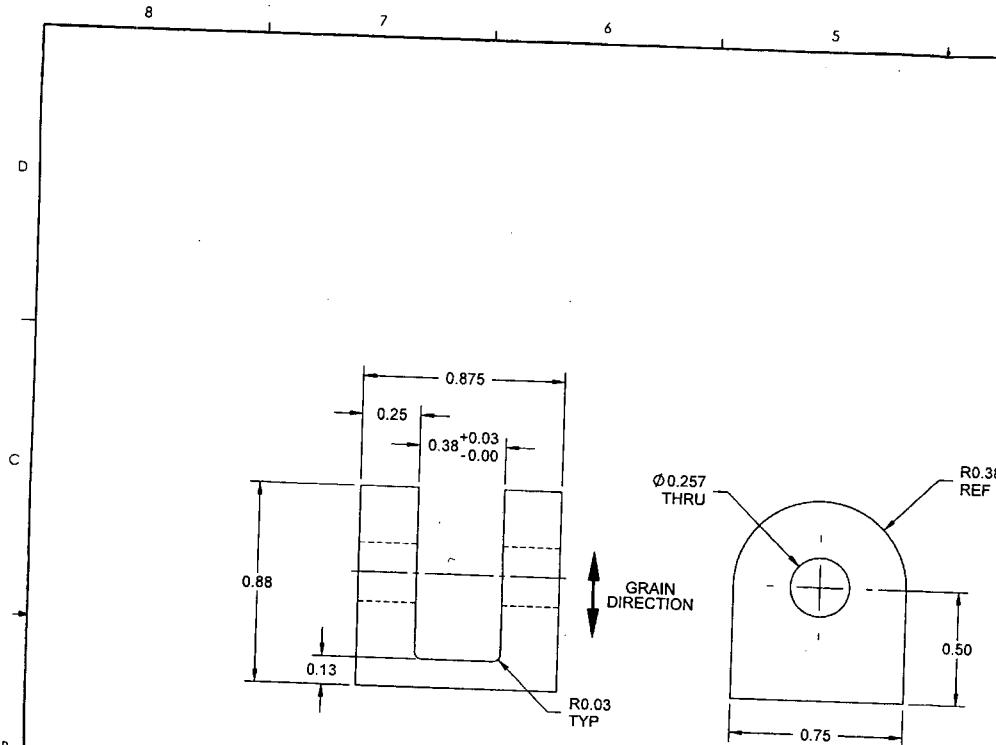
COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT CONTAINS PROPRIETARY MATERIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR PROVIDED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

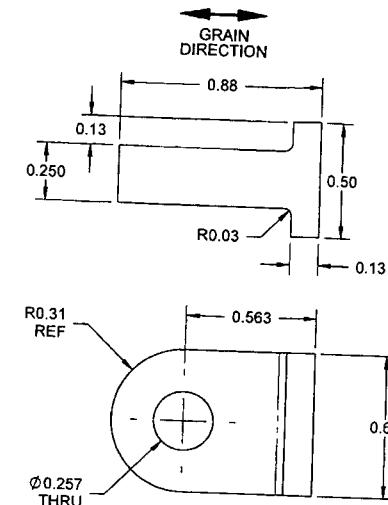
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:
1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

RELEASED
2010-02-16
AP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RP</i>	DRAWING NO.	
MFG. APPR.	<i>RP</i>	D4016	
APPROVED	<i>RP</i>	REV. A	
DE APPR.	<i>RP</i>	SHEET 2 OF 2	
DATE	10.01.29	TITLE	BASKET HINGE
		SCALE	NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries